

Work Order ID 162976

Monday, June 19, 2017 3:05:34 PM

Page 1

Item ID: D3935-1

Accept

Ship 26 June
N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pylon Wall Protector, LH

Start Date: 6/20/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/23/2017 Req'd Qty: 1.00

1

Customer:

Reference:

DAS**JUN 19 2017**

Approvals:

Process Plan:

21~~9-20~~

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3935

B

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.18

1-Cut as per Dwg D3935

Dwg Rev: BProg Rev: B

2- Deburr if necessary

①

α 17/06/22

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.01

①

α 17/06/22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

Work Order ID 162976

Monday, June 19, 2017 3:05:34 PM

162976

Page 2

Item ID: D3935-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pylon Wall Protector, LH
Start Date: 6/20/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/23/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.02				1			DAS 38 9-89 JUN 23 2017
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>PK</u> Memo	0.00 0.01							DAS 6 9-89 JUN 26 2017
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.10							DAS 21 9-89 JUN 26 2017 DAS 21 9-89 JUN 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Monday, June 19, 2017 3:05:37 PM

Page 1

Work Order ID: 162976

162976

Parent Item: D3935-1

D3935-1

Parent Item Name: Pylon Wall Protector, LH

Start Date: 6/20/2017

Required Date: 6/23/2017

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	4,503.006	8.69	10.22353			

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET (DARK GREY)

**

06/17/2017

Location

MAT018

m136228

m137737

Loc Qty

4503.006

663.006

3840

Loc Code

//

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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DART AEROSPACE LTD		Work Order:	162976
Description: Pylon Wall Protector, LH		Part Number:	D3935-1
Inspection Dwg: D3935 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.05	+/-0.030	8.05	/		V-D-Q2	
15.05	+/-0.030	15.05	/		Tap	
19.00	+/-0.030	19.00	/			
19.25	+/-0.030	19.25	/			
20.25	+/-0.030	20.25	/			
23.25	+/-0.030	23.25	/			
24.35	+/-0.030	24.35	/			
29.25	+/-0.030	29.25	/			
32.75	+/-0.030	32.75	/			
1.00	+/-0.030	1.00	/			
3.50	+/-0.030	3.50	/			
9.00	+/-0.030	9.00	/			
17.00	+/-0.030	17.00	/			
18.50	+/-0.030	18.50	/			
33.40	+/-0.030	33.40	/			
34.25	+/-0.030	34.25	/			
34.60	+/-0.030	34.60	/			
34.72	+/-0.030	34.72	/			
22.85	+/-0.030	22.85	/			
19.15	+/-0.030	19.15	/			
35.39	+/-0.030	35.39	/			
0125	+/-0.010	.129	/			

Measured by:	du	Audited by:	Dag 38	Preliminary Approval:	N/A
Date:	17 Dec 2017	Date:	9-89 JUN 23 2017	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.22	New Issue	KJ	
B	10.08.18	Dwg Rev updated	KJ	

DQA: _____ Date: _____

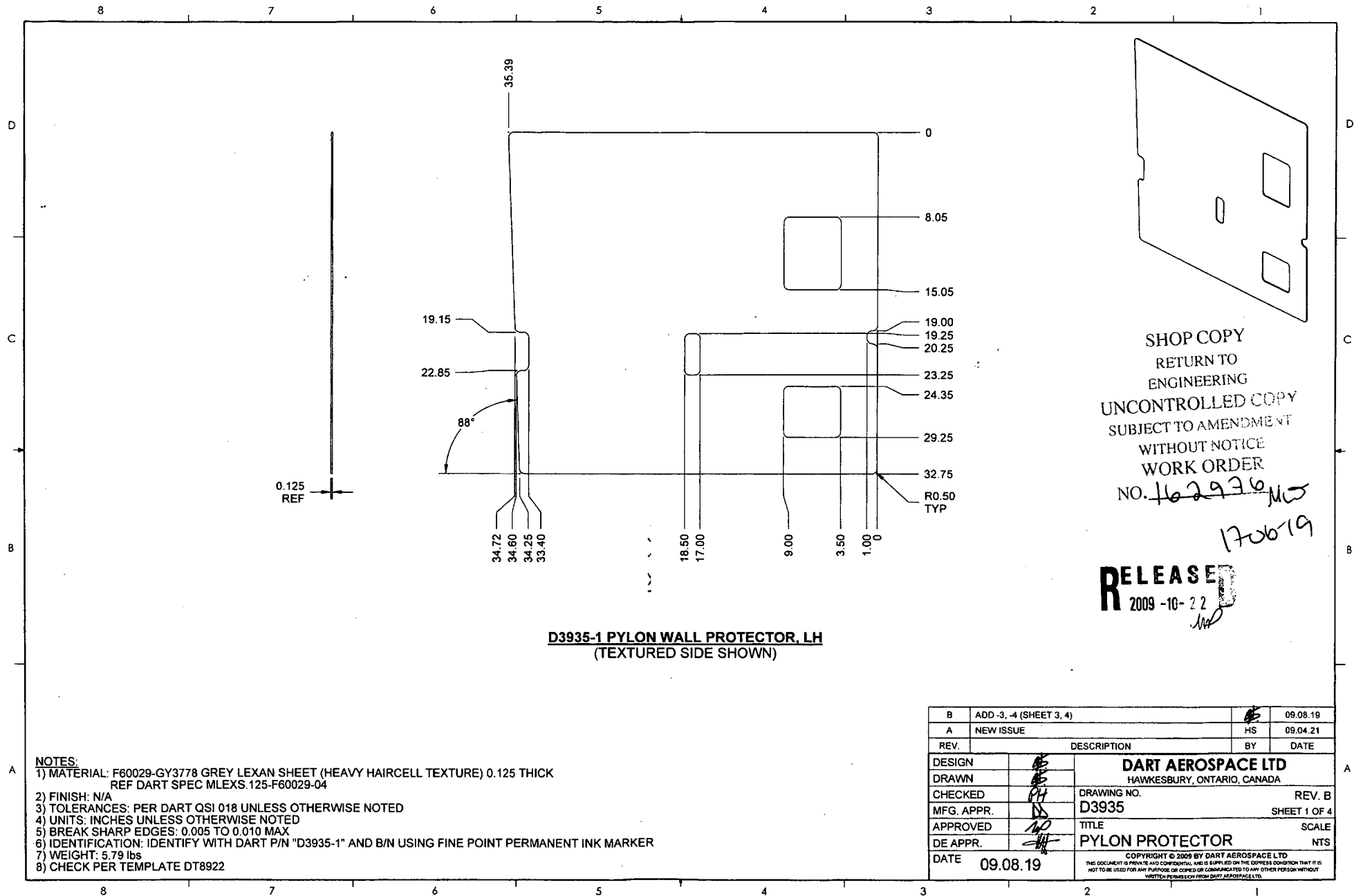


WORK ORDER NON-CONFORMANCE / UPDATE

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		OTHER : ☐			



SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162936

170619

RELEASED
2009-10-22

D3935-1 PYLON WALL PROTECTOR, LH
(TEXTURED SIDE SHOWN)

NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 5.79 lbs
- 8) CHECK PER TEMPLATE DT8922

B	ADD -3, -4 (SHEET 3, 4)	HS	09.08.19
A	NEW ISSUE	HS	09.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.08.19		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3935
REV. B
SHEET 1 OF 4
TITLE
PYLON PROTECTOR
SCALE
NTS

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